

Date: Tuesday, 3/20/2007 12:03:46 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEB	
Job Number	: 31338		Part Number	: D2923	
Estimate Number	: 10482		Drawing Number	: D2923 REV.A	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 3/20/2007 S.O. No. : N/A		Drawing Revision	: A	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 4/4/2007	
Previous Run	: 31114 Type : LANDING GEAR		Qty:	4	Um: Each
Written By			Comment	: Est. B 02.07.26 Updated Location RF	
Checked & Approved By					
Comment					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D26005108	Extrusion 'I Beam' thin Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) D2600-5-108 Extrusion 'I Beam' thin Batch: <u>B 2 9985</u> Jb 7-3-2d
2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1 Comment: LANDING GEAR RESOURCE 1 Cut D2600-5 Extrusion to length as per Dwg D2923. Deburr ends Jb 7-3-2d
3.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1 Comment: LANDING GEAR RESOURCE 1 1- Drill pilot holes in web as per Dwg D2923 using drill jig DT8481 2- Open holes to finish size as per Dwg D2923. 3- Deburr Jb 7-3-2d
4.0	QC5	INSPECT WORK TO CURRENT STEP Comment: INSPECT WORK TO CURRENT STEP Jb 7-3-2d
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 Jb 7-3-2d

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/13/23
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BE 07-03-22

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 16

JB 7-3-22

(4)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/03/03

Job Completion



07/03/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

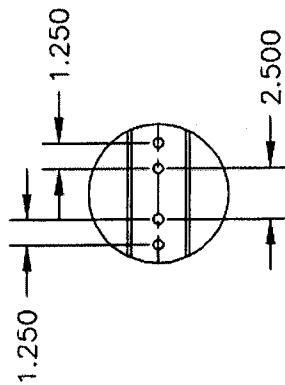
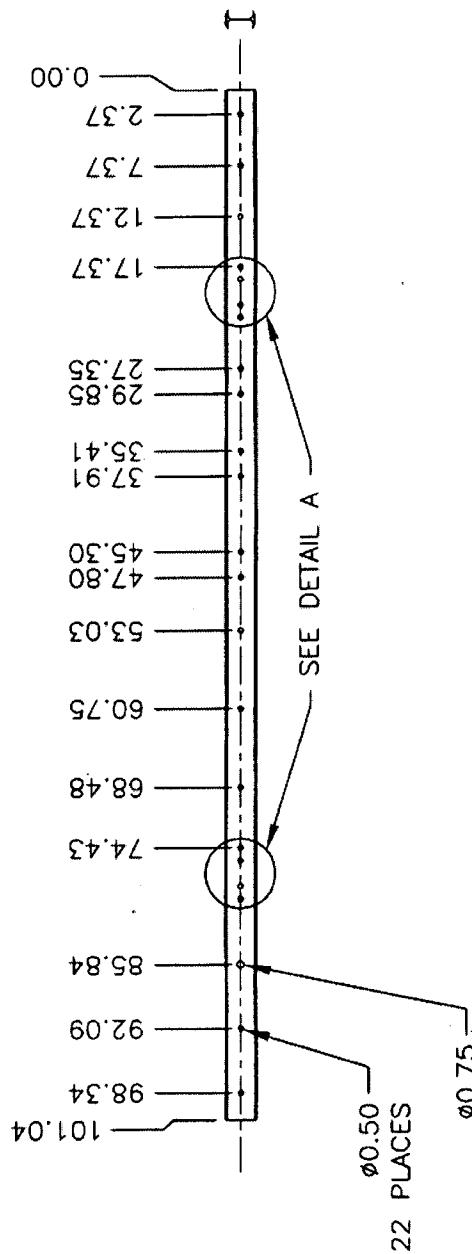
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DARTA COPY IS
MAILED

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED	APPROVED	DRAWING NO. D2923
DATE		REV. A SHEET 1 OF 1
99.10.14		SCALE 1:18
A	99.10.14	NEW ISSUE



SHOW MAKE FROM D2600-5 EXTRUSION
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31338

RELEASED
00.05.11